

Work Order ID 68865



Page 1

Thursday, April 21, 2011 12:43:24 PM

Item ID: D3774-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Bottom, LH/RH

Start Date: 4/21/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: CZ Date: 11/04/21 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3774	Rev B

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Set up machine program D3774-1 Set up clamping frame as per folio

Dh
11/04/21

110

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

x2

Dh
11/04/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Trim to Finished Dimensions	0.00 0.00				x2			PL 11/04/27
150 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo 1) Check dimensions to ensure conformity to drawing tolerances.	0.00 0.00				x2			PL 11/04/27
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				②			

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Page 4

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Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: 207

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/28 ②

11/4/28

MF
11-04-28

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Picklist Print

Thursday, April 21, 2011 12:43:21 PM

Page 1

Work Order ID: 68865



Parent Item: D3774-1



Parent Item Name: Seat Bottom, LH/RH

Start Date: 4/21/2011

Required Date: 5/6/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A New Issue 08.06.04 DL verified by:DD
IPP REV. B Dwg. Update 08.08.19 DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev. C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.125-F60029-04 Purchased No

110 sf 2,384.215 10.667 21.334



GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT018

2384.215789

115261

367

116236

2017.21579

21,334.39

DL
11/04/27

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DART AEROSPACE LTD		Work Order:	68865
Description: Seat Bottom		Part Number:	D3774-1
Inspection Dwg: D3774	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

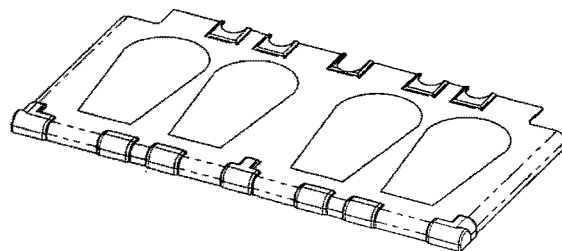
Measured by:	Sh	Date:	11/04/26
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TRIMMING SECTION

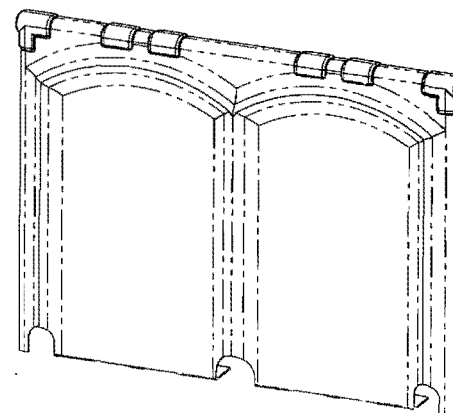
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3	+/-0.100	1.31"	✓		Visual-DL-02	
33.9	+/-0.100	33.8"	✓		TAPEDL-01	
17.4	+/-0.100	17.5"	✓		TAPEDL-01	
0.085	Min	0.090"	✓		CAL TH-01	
0.100	Min	0.101"	✓		CAL TH-DT	
0.100	Min	0.107"	✓		CAL TH-DT	
0.100	Min	0.110"	✓		CAL TH-DT	
0.100	Min	0.106"	✓		CAL TH-DT	

Measured by:	Sh	Date:	11/04/27
Audited by:	JB	Date:	11/04/27
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL	DA



D3774-1 SEAT BOTTOM



D3774-3 SEAT BACK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68865
C24104/21

RELEASED
06-08-11/11

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D8-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES	PH	08.07.25
A	NEW ISSUE	HS	08.06.23
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO.	REV. B
CHECKED	<i>[Signature]</i>	D3774	SHEET 1 OF 3
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	SEAT	NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	08.07.25		

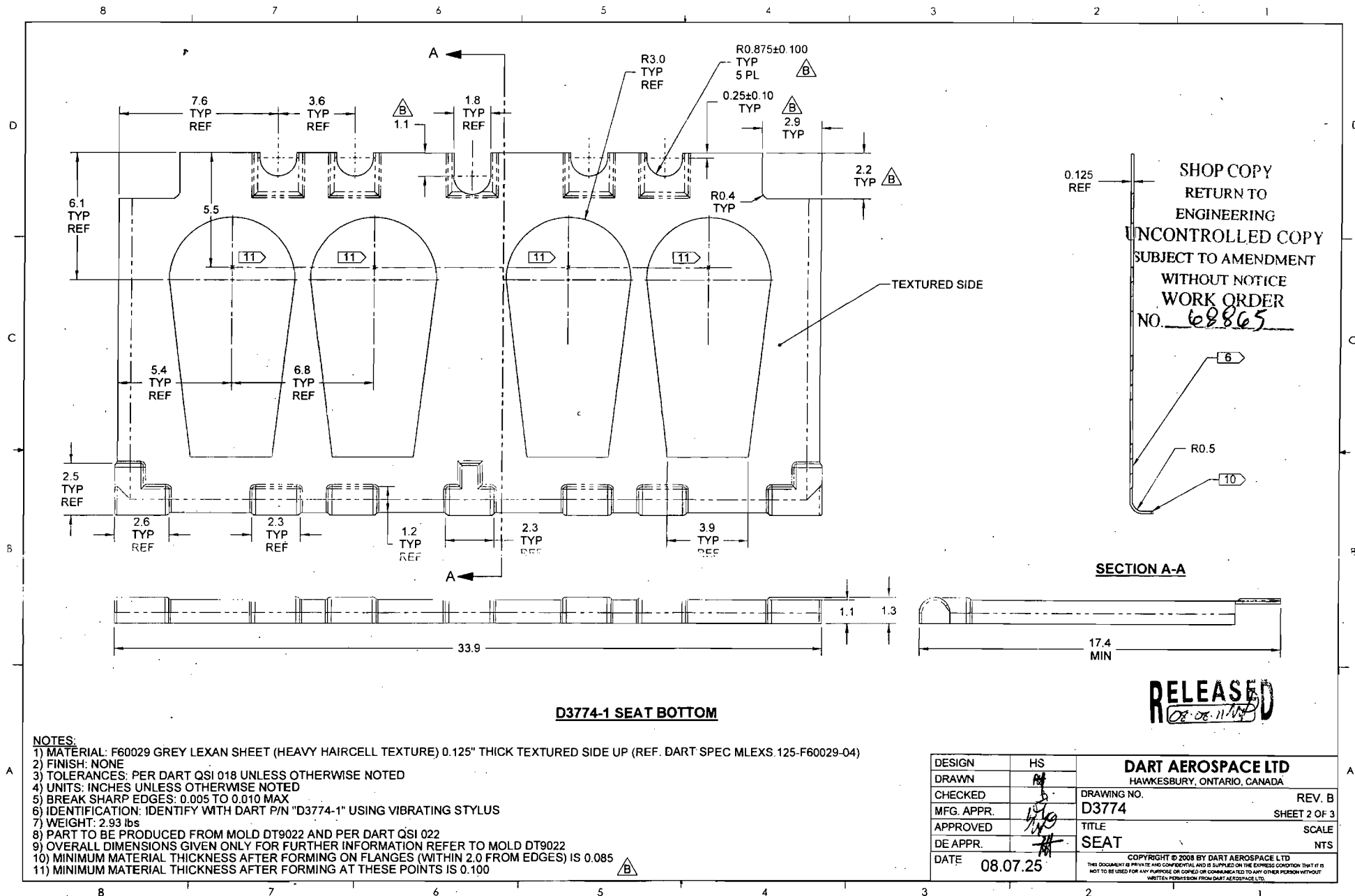
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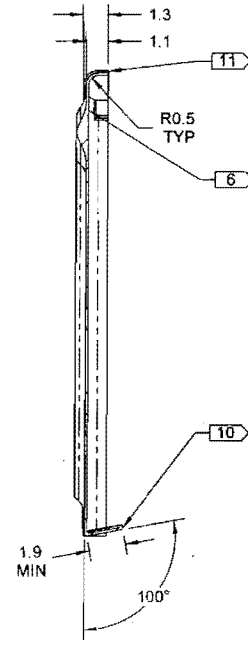
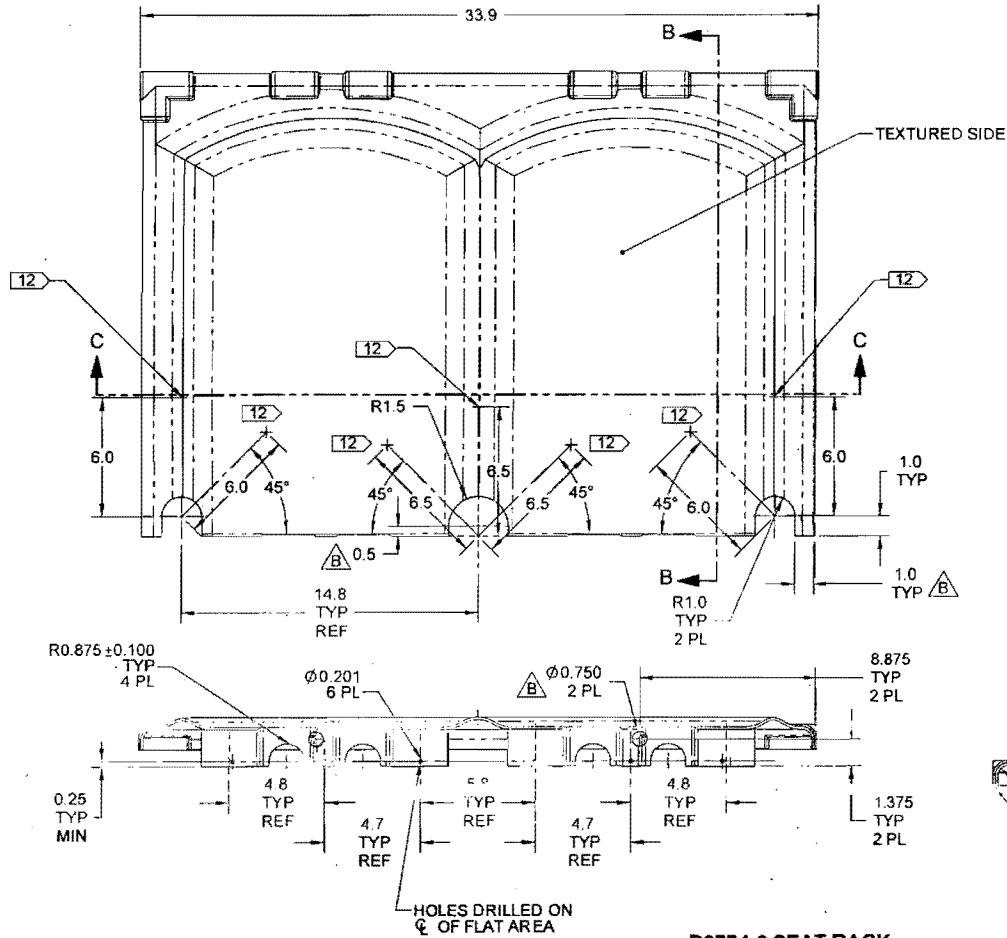
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8 7 6 5 4 3 2 1



SECTION B-B



SECTION C-C

D3774-3 SEAT BACK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68865

RELEASED
08-08-11

- NOTES:
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-3" USING VIBRATING STYLUS
 - 7) WEIGHT: 4.82 lbs
 - 8) PART TO BE PRODUCED FROM MOLD DT9023 AND PER DART QSI 022
 - 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9023
 - 10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON BOTTOM FLANGE IS 0.065
 - 11) MINIMUM MATERIAL THICKNESS AFTER FORMING FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
 - 12) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AD		
CHECKED	AD	DRAWING NO. D3774	REV. B
MFG. APPR.	AD	SHEET 3 OF 3	
APPROVED	AD	TITLE SEAT	SCALE NTS
DE APPR.	AD		
DATE	08.07.25	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

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